

Work Order ID 53834-1

November 20, 2009 8:58:45 AM

Page 1

Item ID: D4011-5

Accept

Revision ID:

Item Name: Clamp, Short

Start Date: 11/19/09

Start Qty: 80.00

Required Date: 11/26/09

Req'd Qty: 80.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4011

B

101

0.00



Waterjet

FLOW CNC Waterjet

Memo

cut per Drwg D4011

Rev. BB Prog. Rev. B

Deburr if necessary

0.00

RB 9-11-21

(115)

102

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

RB 9-11-21

103

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

809/11/23

counts
(114)

φ

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Item ID: D4011-5

Revision ID:

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Start Date: 11/19/09 Start Qty: 80.00

Required Date: 11/26/09 Req'd Qty: 80.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tooling:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

104



Small Fab

Small Fab

Memo

Form as per drwg
D4011 Rev.B

0.00

0.00

80 09/11/24

16

105



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

80 09/11/24

(216) 4

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

109/14/24 (16)



Work Order ID 53834

November 20, 2009 8:58:46 AM

Item ID: D4011-5

Revision ID:

Item Name: Clamp, Short

Start Date: 11/19/09 Start Qty: 80.00

Required Date: 11/26/09 Req'd Qty: 80.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

140



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

09/11/24

MK 09-11-24

Print

ember 20, 2009 8:58:45 AM

Page 1

Work Order ID: 53834

Parent Item: D4011-5

Parent Item Name: Clamp, Short

Comments: IPP RevA:(new issue) revC as per dwg 09.11.18 DD verified by:JLM

Start Date: 11/19/09

Required Date: 11/26/09

Start Qty: 80.00

Required Qty: 80.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S14GA

Purchased

No

sf

25.9521

4.8000

7.



304SS sheet .080

189-11-21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

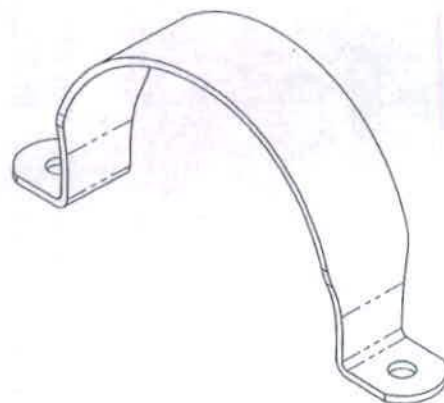
25.9521

110993Q

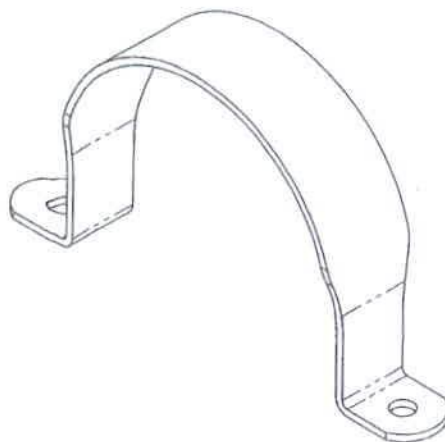
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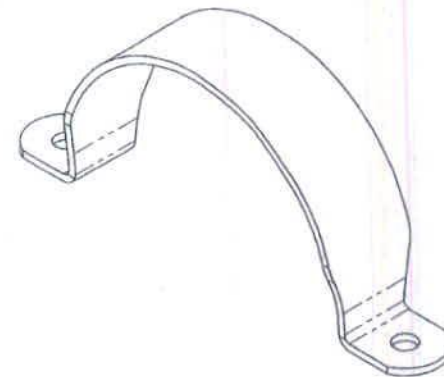
115



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



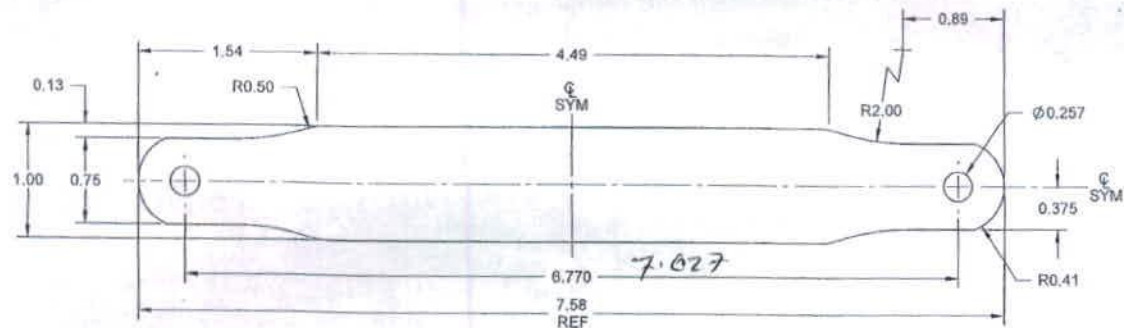
D4011-5 CLAMP, SHORT (OEM)

53834

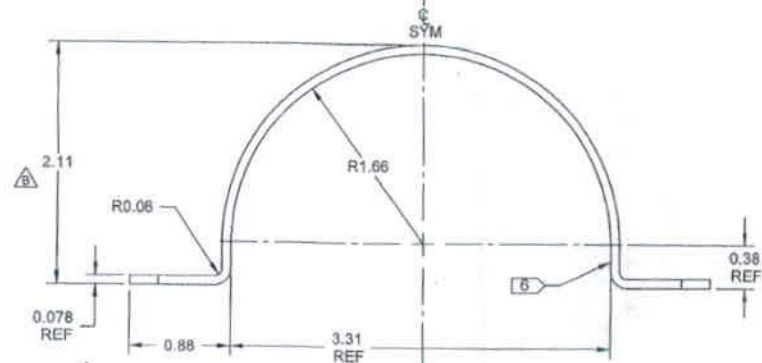
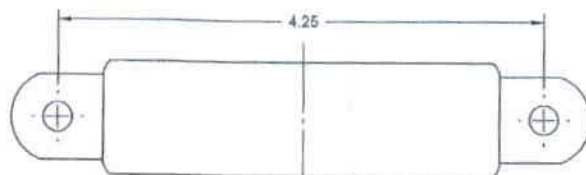
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

B	SHORTEN HEIGHT OF 143 CLAMPS BY 0.125, ADDED -S. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKID TUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.11		
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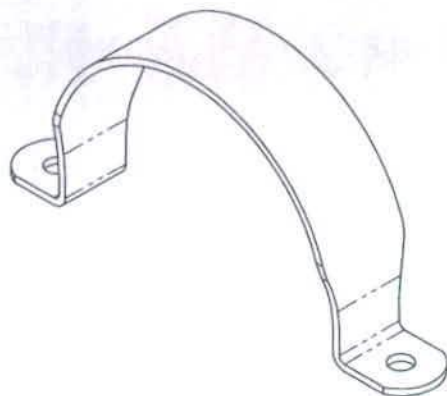
D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN



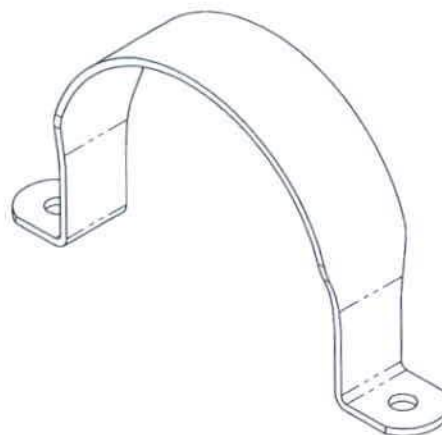
D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

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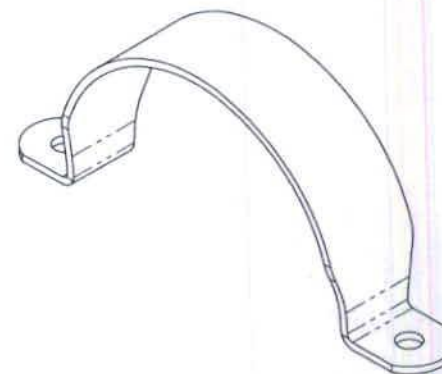
53834



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



D4011-5 CLAMP, SHORT (OEM)

53834

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NOTES:

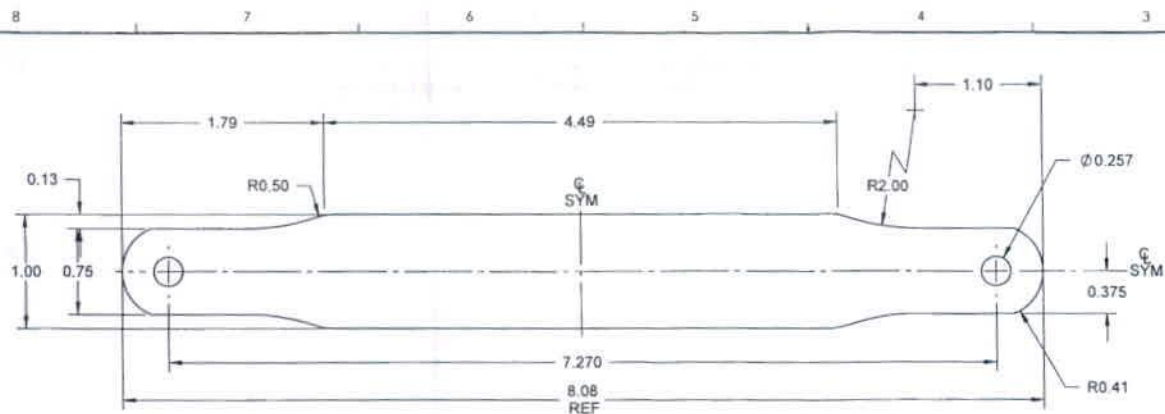
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

B	SHORTEN HEIGHT OF -1A-3 CLAMPS BY 0.125; ADDED -5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MR	09.11.11
A	NEW ISSUE	MB	09.10.21
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.11		

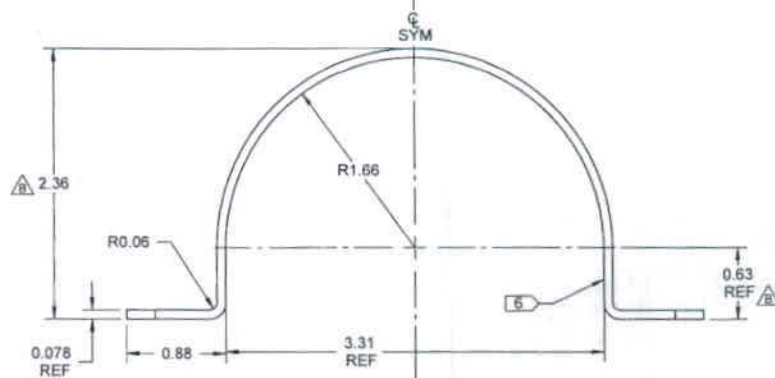
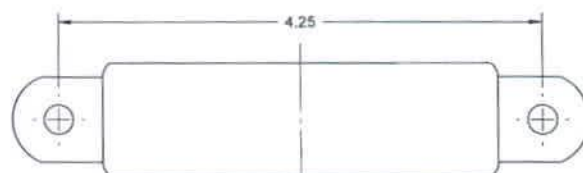
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4011** REV. B
SHEET 1 OF 4
TITLE **CLAMP** SCALE NTS

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D4011-1F CLAMP, SHORT FLAT PATTERN



**D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)**

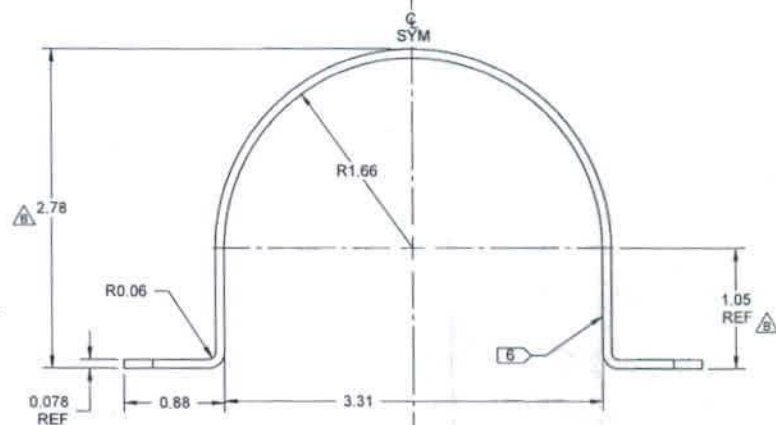
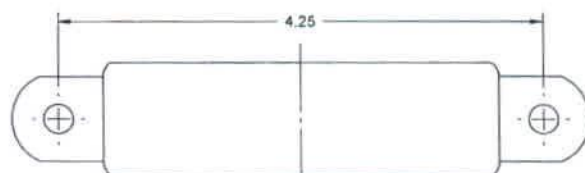
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D4011-3F CLAMP FLAT PATTERN, LONG

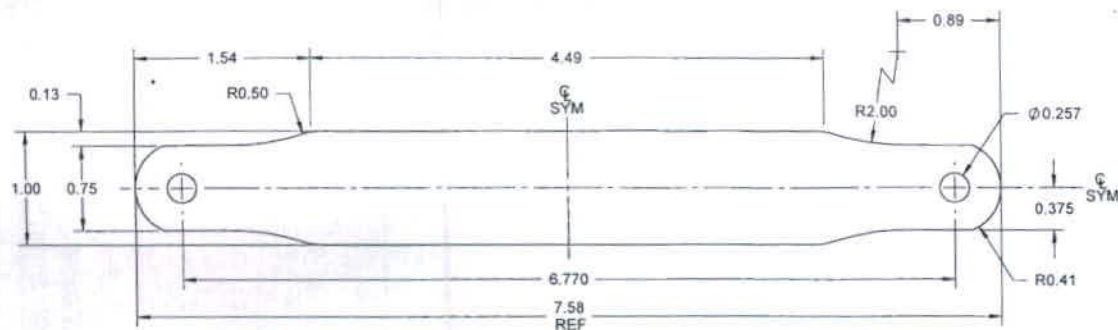


D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

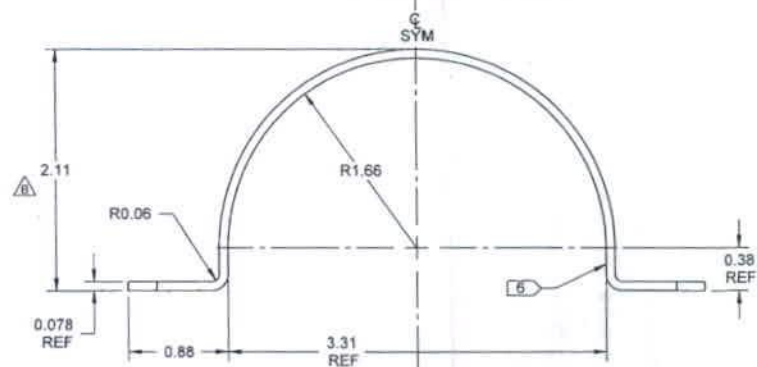
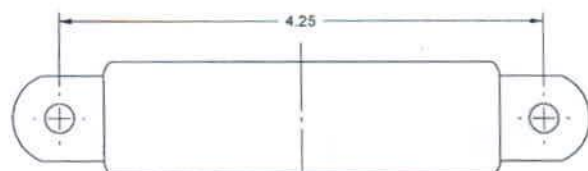
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D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN



D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

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